

## AMENDMENTS TO THE SPECIFICATION

Amend the paragraph no. [0048] as follows:

[0048] The invention also contemplates an alternate embodiment of the special smoothing tool ~~[[40]]~~ 60 that is illustrated generally at 60 in Figs. 10 and 11.

Components shown in Figs. 10 and 11 that are the same as components shown in previous figures have the same numerical identifiers. The tool 60 has a rhombic shaped body 42 having a bore 43 formed therethrough which receives a fastener (not shown) for securing the tool to the tool holder 41. The tool 40 is formed from a sintered carbide steel and includes an insert 64 attached to one end. The insert 64 is formed from a mono crystalline material which may be either naturally occurring or synthetically produced. In the preferred embodiment, the insert 64 is formed from a Single Crystalline Diamond (SCD) material. The insert 64 includes an improved cutting tip 65 on one end that contacts the wheel face 31 and works the metal. The arrow in the upper left portion of Fig. 10 indicates the direction of movement of the worked metal, or the wheel, relative to the smoothing tool 40. As before, the insert 64 has a length L of about six mm.

Amend the paragraph no. [0051] as follows:

[0051] Similar to the poly crystalline insert ~~[[40]]~~ 44 described above, the present invention contemplates that, in the preferred embodiment, the feed rate per revolution for a wheel lathe utilizing the tool 60 having the mono-crystalline insert 64 is less than the cutting tip radius R.